



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Canada

Tel (613) 632-5200

D3903-1

Job Sheet 179225



Part No: D3903-1

Job Qty: 200 Ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/14/18

Job Tracking No:

Due Date: 6/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP RevA: New issue DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	200 Ea		6/22/18	0.00	0.00	Start Up Machining-2		JB 18-06-26
100	Hardinge	200 pcs		6/22/18	0.00	5.41	Hardinge		JB 18-06-26
110	QC	200 pcs		6/22/18	0.00	0.00	QC2 Machining-2		JB 18-06-26
120	QC	200 pcs		6/22/18	0.00	0.00	QC8 Machining-2		JB 18-06-27
125	Skidtubes	200 pcs		6/22/18	0.00	1.29	Skidtubes-2		JB
130	Packaging	200 pcs		6/22/18	0.00	0.00	Packaging3-2		JB
140	QC21-SA	200 Ea		6/22/18	0.00	0.00	QC21		JB

Part Op 100 - 1-TURN AS PER FOLIO FA813 & DWG D3903,
Descriptions: 125 - Clean spacers with Ultra Aluminum Cleaner
130 - LOCATION : LG001

DAS
21 JUN 27 2018
9-56

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.625	6061-T6 Round Bar .625"	69 ft (.345 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.625 M6061T6T0.375 x 10.053	69	42	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.375Inches + 0.006 - 0.001	0.381 0.374		Diameter
2	Spacer	0.259Inches + 0.006 - 0.001	0.265 0.258		Diameter
3	Spacer	4.080Inches ± 0.030	4.110 4.050		
4	Spacer	0.030Inches ± 0.010	0.040 0.020		
5	Spacer	45.000Degrees ± 0.500	45.500 44.500		angle

WORK ORDER NON-CONFORMANCE / UPDATE



DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION				AGAINST DEPARTMENT/PROCESS				Engineering Quality Other							
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐				Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐				Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐				Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐			
NCR No. _____		Suspected Unapproved ☐				QTY Effective : _____				MRB (QSI042) Approval							
Date : _____		Step #: _____		Description Work Order Deviation													
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Completed By										QC / QA Coordinator Approval					
		Lead hand / Supervisor Approval Verification															
Container No: S084655 Part: D3903 - 1 Job No: 179225 Serial No/Batch: S084655 Revision: Inspector: Exp Date: Instructions: Date: 06/26/18																	
OTHER : _____																	

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